

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003685**Date Inspected:** 12-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2200**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Sherri Brannon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

**Bay 2 Sub Assembly Shop:**

114 Meter Mock-UP- Caltrans QA Inspector observed the 114 Meter Mock-up to be idle during this shift.

Rolling- Caltrans QA observed Inspector no plates were rolled on this date to correct flatness dimensions.

Thermal Cutting- Caltrans QA Inspector observed ZPMC cutting plates for OBG side/bottom panels.

Milling- Caltrans QA Inspector observed ZPMC using the horizontal milling machine to mill beveled edges of various tower web plates.

**Bay 8- Sub Assembly Shop - Tower Double Diaphragm**

In-Process Welding – QA Inspector Brannon randomly observed ZPMC CJP welding double diaphragm

ESD1-SA316 B/B weld joint #1 & 2 using a SMAW process for the fill/cover pass.

**Tower Shop-Bay 1**

Thermal Cutting- QA Inspector Brannon randomly observed ZPMC cutting tower skin stiffener plates.

Milling- Caltrans QA Inspector observed ZPMC using the horizontal milling machine to mill beveled edges of various tower web plates.

ZPMC NDT- QA Inspector Brannon randomly observed ZPMC performing MT on South Tower Skin Assembly, Skin E tack welds. ABF Rep informed QA of 1 tack weld that had cracked at SSD1-SA16A A/G weld joint 64,

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## WELDING INSPECTION REPORT

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12mm in length.

### Tower Shop-Bay 2

Thermal Cutting- QA Inspector Brannon randomly observed ZPMC cutting plates for OBG floor beam web plates and tower skin stiffener plates.

Milling- QA Inspector Brannon randomly observed ZPMC using the horizontal milling machine to mill beveled edges of various tower web plates.

Fit-Up & Tack - QA Inspector Brannon randomly observed ZPMC in the process of fit-up, tack welding for the East Tower Skin Assembly, Skin B using a SMAW process on this date

### Summary of Conversations:

No relevant conversations to report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi 137-6471-0411 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Brannon, Sherri	Quality Assurance Inspector
<b>Reviewed By:</b>	Lanz, Joe	QA Reviewer

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